

Work Order ID 97631

February-21-13 9:29:41 AM

97631

Page 1

Item ID: D350-689-043 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Dual High Back Seat Assembly
 Start Date: 2/21/13 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 2/21/13 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: W Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D350-689	B								
100		0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Document Control	Photocopy bluefile and create labels per PPP D350-689-043 CHG002								
150		0.00							
150	Large Fab								
Large Fab	Memo	0.00							
Large Fab	PULL FROM STOCK: 1 X D350-689-041 B94661 ASSEMBLE TO -043 Assemble as per IIN 350-689								
160		0.00							
160	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

DAS
15
2-23

13221

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1

Work Order ID 97631

97631

Page 2

February-21-13 9:29:41 AM

Item ID: D350-689-043 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Dual High Back Seat Assembly
 Start Date: 2/21/13 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 2/21/13 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Identify as per dwg & Stock Location: _____	0.00							
170									
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									



B/2/21

MLJ 13-02-21

MF
13-2-21

Picklist Print

February-21-13 9:29:39 AM

Page 1

Work Order ID: 97631

Parent Item: D350-689-043

Parent Item Name: Dual High Back Seat Assembly

Start Date: 2/21/13

Required Date: 2/21/13

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 08-12-24 new issue DD verified by:ECI PP Rev:B as per DSI 9498 DD 10.02.12
verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3-12A Bolt		Purchased	No			150	Each	166.0000	3	3			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		18							
				122407		18							
				ST351		48							
				114536		1							
				123352		47							
				ST512		100							
				123759		100							
D3024-1 Spacer		Manufactured	No			150	Each	25.0000	3	3			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST024		25							
				91849		5							
				95346		20							
D3031-1 Loop		Manufactured	No			150	Each	11.0000	2	2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		5							
				79747		5							
				ST024		6							
				91847		6							
D350-689-041 Dual High Back Seat Ass'y		Manufactured	No				Each	1.0000					
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				FG		1							
				94661		1							

94661¹ W 13.02.21

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Page 2

Work Order ID: 97631

Parent Item: D350-689-043

Parent Item Name: Dual High Back Seat Assembly

Start Date: 2/21/13

Required Date: 2/21/13

Start Qty: 1.00

Required Qty: 1.00

D3808-041
Seat Rail Assembly

Manufactured No

150 Each 6.0000 2 2

Location

Loc Qty

Loc Code

ST248

6

90348

2

91782

2

91964

2

D3809-1
Sliding Block

Manufactured No

150 Each 33.0000 4 4

Location

Loc Qty

Loc Code

ST066

33

87420

1

91898

10

96429

22

MS20600-AD4W2
Rivet

Purchased No

110 Each 214.0000 40 40

Location

Loc Qty

Loc Code

ST311

214

124231

214

MS20600-AD4W3
Cherry Rivets

Purchased No

150 Each 1,379.0000 6 6

Location

Loc Qty

Loc Code

ST311

1246

122151

10

122452

7

123525

329

124231

900

WA003

133

107939

133

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Page 3

Work Order ID: 97631

Parent Item: D350-689-043

Parent Item Name: Dual High Back Seat Assembly

Start Date: 2/21/13

Required Date: 2/21/13

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

150

Each

7,064.0000

17

17

Nut

Location

Loc Qty

Loc Code

FP001

3

122141

3

GA

354

122452

354

ST314

268

117885

32

119017

55

119075

138

123265

43

ST506

6439

123900

2439

124291

4000

MS21042L4

Purchased

No

150

Each

5,274.0000

6

6

Nut

Location

Loc Qty

Loc Code

FP001

318

122452

306

8182

12

FP-001

12

8182

12

GA

221

121444

221

ST314

223

116548

12

119017

20

123248

175

123355

16

ST506

1500

123900

1500

ST518

3000

124231

3000

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Shop Packet Print

Page 3

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Page 5

Work Order ID: 97631

Parent Item: D350-689-043

Start Date: 2/21/13

Required Date: 2/21/13

Parent Item Name: Dual High Back Seat Assembly

Start Qty: 1.00

Required Qty: 1.00

MS27039-4-21
Screw

N/A

Purchased No

150 Each 51.0000 6 6

Location	Loc Qty	Loc Code
ST307	51	
122452	1	
124586	50	

NAS1149D0332J
Washer

N/A

Purchased No

150 Each 929.0000 17 17

Location	Loc Qty	Loc Code
FP001	44	
122973	44	
ST294	885	
122973	885	

NAS1149D0432J
WASHER

N/A

Purchased No

150 Each 234.0000 6 6

Location	Loc Qty	Loc Code
GA	1	
116583	1	
ST293	200	
124580	200	
ST294	33	
116583	33	

D3030-1

- 2

90641

D3029-1

- 2

90659

u return to stock

D3028-1

- 4

91875

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D350-689 REV. B AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-689 REV. 1

REF. TCCA STC: SH02-33
REF. FAA STC: SR01620NY
REF. EASA STC: EASA.IM.R.S.01453
REF. TCA STC: 2005S03-09

1.0 PURPOSE

For D350-689-011/-013 at CHG 006/005 and later and D350-689-021/-023 Kits at CHG 005/004 and later, the D3026-1 Channel has been replaced with the D4575-1 Beam and D4575-3 Doubler and the D3234-3 Doubler has been removed. Consequently, the installation instructions for D350-689-011/-013 at CHG 006/005 and D350-689-021/-023 at CHG 005/004 are updated per Section 2.0 of this Service Instruction. The parts list update is shown in Section 4.0 of this Service Instruction. There is a negligible change to the weight and balance.

2.0 INSTALLATION CHANGES FOR D350-689-013

Section 3.9, *INSTALLATION OF D350-689-013 FLOOR PROVISIONS KIT* (pages 4 and 5 of IIN-D350-689), is changed as follows:

Item 3.3.15 is:

If there is an existing stringer at LBL 27.33, it will need to be removed from that location. Locate D4575-1 Beam, D4575-3 Doubler, and D3032-1 Spacer as shown in Figure 1 of this Service Instruction. Transfer drill existing holes from the aircraft floor to the D4575-1 Beam, D4575-3 Doubler, and D3032-1 Spacer. Ensure 1.0" to 1.5" rivet pitch and add additional holes if required. If there is no existing stringer, locate D4575-1 Beam, D4575-3 Doubler, and D3032-1 Spacer as shown in Figure 1 of this Service Instruction and drill Ø0.128" holes on a 1.0" to 1.5" pitch.

Note: Drill a Ø1.00" (Ø25.4 mm) hole in the D4575-1 Beam to clear extension tube of collective and cutout as required for clearance of collective opening and fwd bulkhead as shown in Figure 3 of this Service Instruction.

Item 3.3.15 was:

If there is an existing stringer at LBL 27.33, it will need to be removed from that location. Locate D3026-1 Channel as shown in Figure 4 and transfer existing holes from the aircraft floor to the D3026-1 Channel & D3032-1 Spacer. Ensure 1.0" to 1.5" rivet pitch and add additional holes if required. If there is no existing stringer, locate D3026-1 Channel & D3032-1 Spacer as shown in Figure 4 and drill Ø0.128" holes on a 1.0" to 1.5" pitch.

Item 3.3.17 is:

Counter sink holes in the D3032-1 Spacer for MS20426AD4 rivets. Install D4575-1 Beam, D4575-3 Doubler, and D3032-1 Spacer to floor using MS20426AD4 rivets.

Item 3.3.17 was:

Counter sink holes in the D3032-1 Spacer for MS20426AD4 rivets. Install D3026-1 Channel and D3032-1 Spacer using MS20426AD4 rivets.

Item 3.3.22 is:

Rivet D3234-1 Doubler to D3025-1 Beam as shown in Figure 7 using MS20470AD4 rivets. Continue at step 3.3.25.

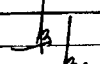
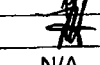
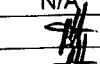
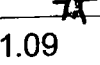

Item 3.3.22 was:

Rivet D3234-1 Doubler to D3025-1 Beam and D3234-3 Doubler to D3026-1 Channel as shown in Figure 7 using MS20470AD4 rivets. Continue at step 3.2.25.

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DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: 
D. SHEPHERD (DE # 02)

DATE: 12.11.09
CERT. NO.: SH02-33
ISSUE NO.: 1

B	CHANGES TO -013 KIT INSTALLATION. REF: CIR12-12.	MB	12.11.09
A	NEW ISSUE	MB	11.12.22
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD	
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CHECKED		DRAWING NO.	REV. B
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3.0 INSTALLATION CHANGES FOR D350-689-023

Section 3.9, *INSTALLATION OF D350-689-023 ENERGY ATTENUATING FLOOR PROVISIONS KIT* (pages 8 and 9 of IIN-D350-689), is changed as follows:

Item 3.9.8 is:

If there is an existing stringer at LBL 27.33, it will need to be removed from that location. Locate D4575-1 Beam and D4575-3 Doubler as shown in Figure 2 of this Service Instruction. Transfer drill existing holes from the aircraft floor to the D4575-1 Beam and D4575-3 Doubler. Ensure 1.0" to 1.5" rivet pitch and add additional holes if required. If there is no existing stringer, locate D4575-1 Beam and D4575-3 Doubler as shown in Figure 1 of this Service Instruction and drill Ø0.128" holes on a 1.0" to 1.5" pitch.

Note: Drill a Ø1.00" (Ø25.4 mm) hole in the D4575-1 Beam to clear extension tube of collective and cutout as required for clearance of collective opening and fwd bulkhead as shown in Figure 3 of this Service Instruction.

Item 3.9.8 was:

If there is an existing stringer at LBL 27.33, it will need to be removed from that location. Locate D3026-1 Channel as shown in Figure 4 and transfer existing holes from the aircraft floor to the D3026-1 Channel. Ensure 1.0" to 1.5" rivet pitch and add additional holes if required. If there is no existing stringer, locate D3026-1 Channel as shown in Figure 4 and drill Ø0.128" holes on a 1.0" to 1.5" pitch.

Item 3.9.10 is:

Attach D4575-1 Beam and D4575-3 Doubler to floor using qty (14) MS20426AD4 rivets.

Item 3.9.10 was:

Attach D4575-1 Channel to floor using qty (14) MS20426AD4 rivets.

Item 3.9.12 is no longer applicable:

~~Rivet D3234-3 Doubler to D3026-1 Channel as shown in Figure 7 using MS20470AD4 rivets.~~

Item 3.9.12 was:

Rivet D3234-3 Doubler to D3026-1 Channel as shown in Figure 7 using MS20470AD4 rivets.

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




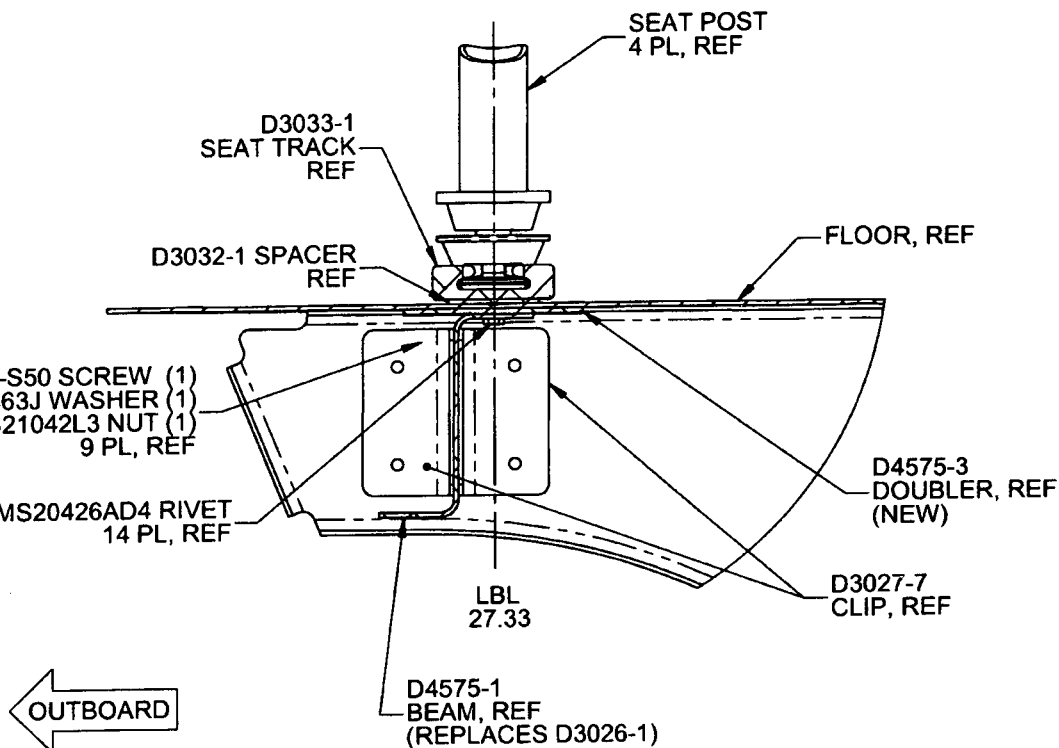
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FIGURE 3
(OF THIS DSI)

FIGURE 3
(OF THIS DSI)



CROSS SECTION VIEW F-F/M-M: From Figures 5 and 7 (IIN-D350-689)
CROSS SECTION VIEW F-F/M-M: From Figures 25-5 and 25-7 (ICA-D350-689)

FIGURE 1: UPDATES TO CROSS SECTIONS F-F AND M-M
 With reference to Figures 5 and 7 of IIN-D350-689
 (Figures 25-5 and 25-7 of ICA-D350-689)

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 BY: *[Signature]*
 D. SHEPHERD (DE # 02)

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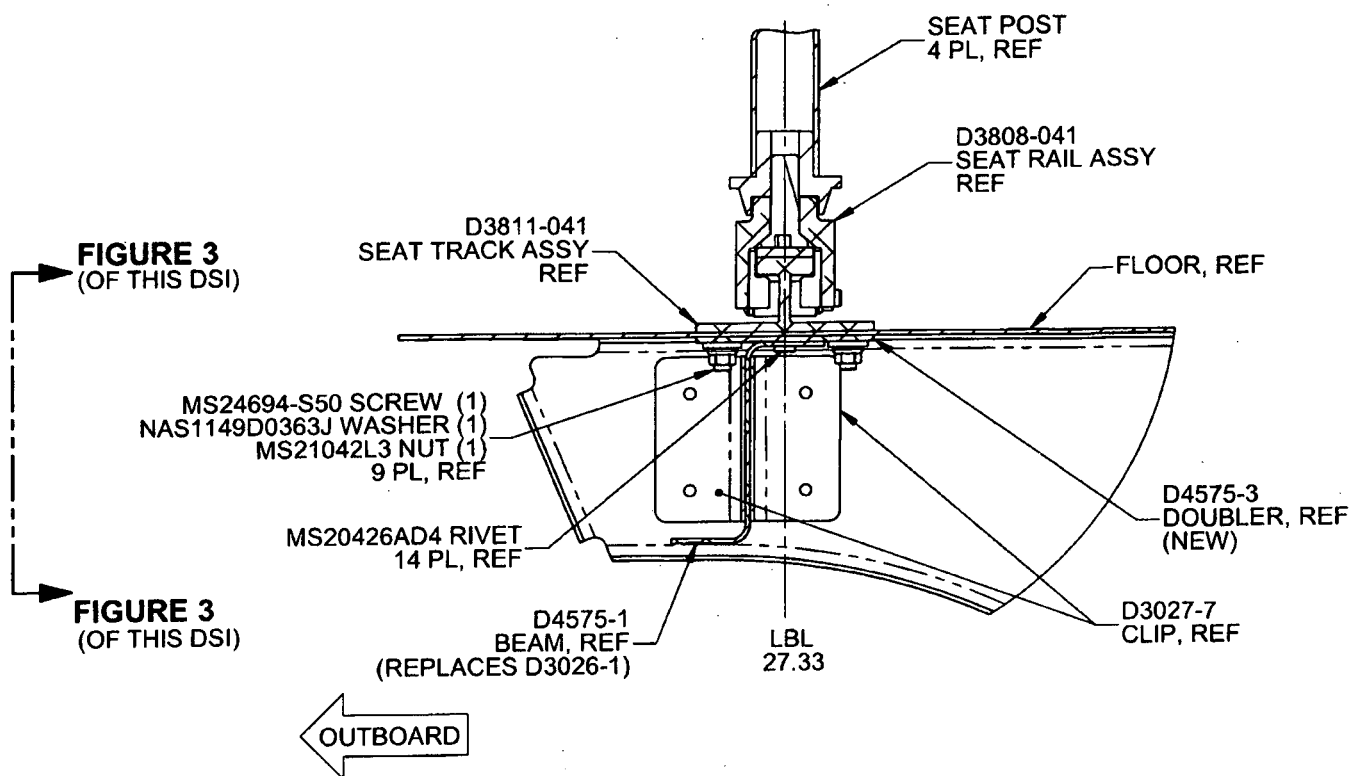


FIGURE 21: Cross Section View T-T from Figure 19 (IIN-D350-689)
FIGURE 25-21: Cross Section View T-T from Figure 25-19 (ICA-D350-689)

FIGURE 2: UPDATES TO FIGURE 21 (IIN-D350-689) AND 25-21 (ICA-D350-689)
 With reference to Figures 19 and 20 of IIN-D350-689
 (Figures 25-19 and 25-20 of ICA-D350-689)

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DATE: 12.11.09
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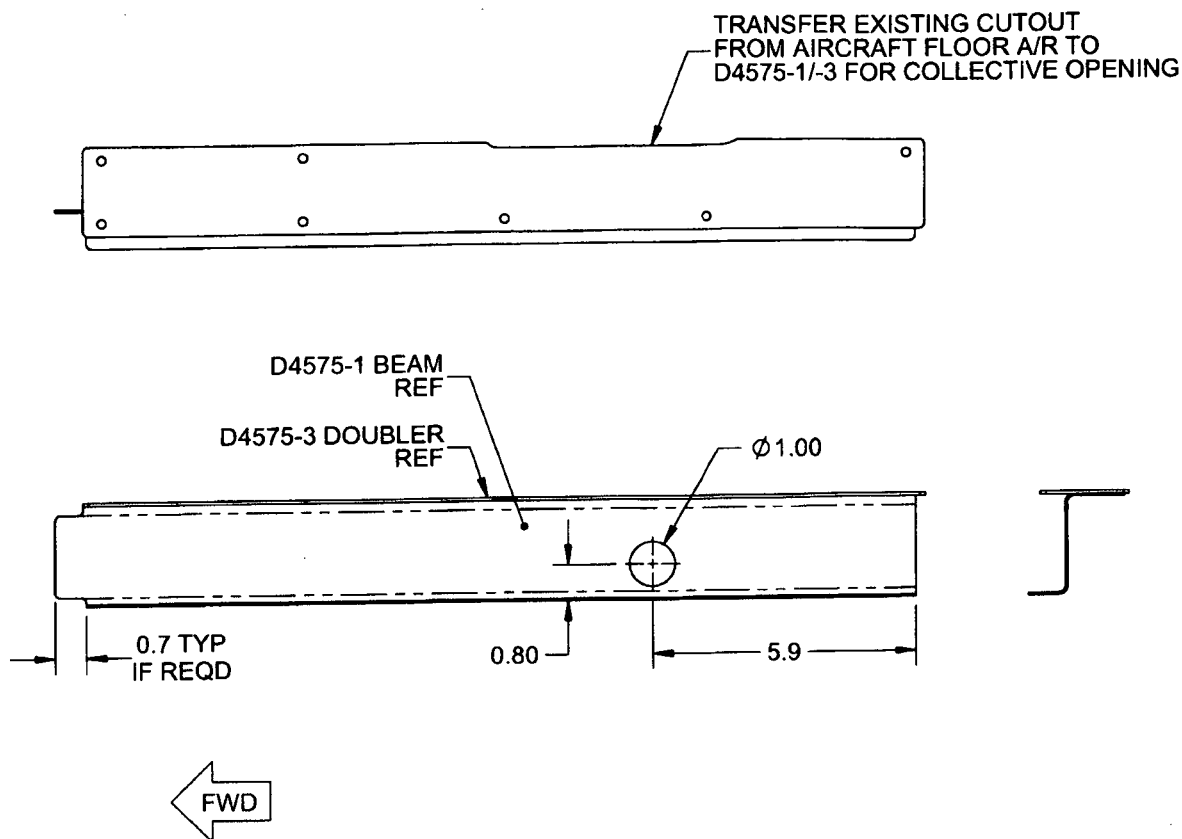


FIGURE 3: RELIEFS ON D4575-1/-3
(ONLY D4575-1/-3 SHOWN FOR CLARITY)
VIEW LOOKING INBOARD

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4.0 PARTS LIST CHANGE

The parts list of D350-689-021/-023 at CHG 005/004 or later is amended as follows:

5. PARTS LIST (IIN-D350-689)

25.10 PARTS LIST (ICA-D350-689)

IS:

Qty -011	Qty -013	Qty -015	Qty -017	Qty -019	Qty -021	Qty -023	Qty -041	Qty -043	Part Number	Description
X									D350-689-011	DUAL HIGH BACK SEAT INSTALLATION, LH
1	X								D350-689-013	FLOOR PROVISIONS KIT
		X							D350-689-015	SEAT MODIFICATION KIT
			X						D350-689-017	SHOULDER HARNESS KIT
				X					D350-689-019	CONTROL GUARD KIT
					X				D350-689-021	DUAL HIGH BACK SEAT INSTALLATION, LH
					1	X			D350-689-023	ENERGY ATTENUATING FLOOR PROVISIONS KIT
1							X		D350-689-041	DUAL HIGH BACK SEAT ASSEMBLY
					1			X	D350-689-043	DUAL HIGH BACK SEAT ASSEMBLY
									D3026-1	CHANNEL (REMOVED)
									D3234-3	DOUBLER (REMOVED)
	1					1			D4575-1	BEAM (REPLACES D3026-1)
	1					1			D4575-3	DOUBLER (NEW)

WAS:

Qty -011	Qty -013	Qty -015	Qty -017	Qty -019	Qty -021	Qty -023	Qty -041	Qty -043	Part Number	Description
X									D350-689-011	DUAL HIGH BACK SEAT INSTALLATION, LH
1	X								D350-689-013	FLOOR PROVISIONS KIT
		X							D350-689-015	SEAT MODIFICATION KIT
			X						D350-689-017	SHOULDER HARNESS KIT
				X					D350-689-019	CONTROL GUARD KIT
					X				D350-689-021	DUAL HIGH BACK SEAT INSTALLATION, LH
					1	X			D350-689-023	ENERGY ATTENUATING FLOOR PROVISIONS KIT
1							X		D350-689-041	DUAL HIGH BACK SEAT ASSEMBLY
					1			X	D350-689-043	DUAL HIGH BACK SEAT ASSEMBLY
	1					1			D3026-1	CHANNEL
	1					1			D3234-3	DOUBLER

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D. SHEPHERD (DE # 02)

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DRAWN	<i>B</i>		SHEET 6 OF 6
CHECKED	<i>TH</i>		
MFG. APPR.	N/A		
APPROVED	<i>TH</i>		
DE APPR.	<i>TH</i>		NTS
DATE 12.11.09			